

Date: Friday, 03/04/2009 10:19:26 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: VERTICAL TUNNEL L/H
Job Number	: 46912		
Estimate Number	: 13585		
P.O. Number	:	Part Number	: D38221
This Issue	: 03/04/2009 S.O. No. :	Drawing Number	: D3822 PRELIMINARY
Prsht Rev.	: NC	Project Number	: IN0002
First Issue	: / / Type : THERMOFORMING	Drawing Revision	: B PRELIMINAR
Previous Run	: 44457	Material	: MKYD6185S080P362015
Written By	:	Due Date	: 10/04/2009 Qty: 2 Um: Each
Checked & Approved By	JW 09.04.03		
Comment	: Est. A New Issue 08/09/17 DL Rev. B Dwg. Update 09/02/09 DL verified by:DD		

Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MKYD6185S080P362015	6185 KYDEX .080"
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Comment: Qty.: 7.4028 sf(s)/Unit Total : 14.8056 sf(s)
 6185 Kydex .080"

M109703

2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Machine set up

BB 09/04/02 x 1

3.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
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Comment: HAND FINISHING THERMOFORMING

1) Cut sheet to required blank size

BB 09/04/02 x 3

4.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: THERMOFORMING MACHINE

Thermoform as per Dwg. D3822-1 and folio (FTA 025) using tool DT 9073

Dwg. Rev. 3

Folio Rev. 3

BB 09/04/02 x 3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 03/04/2009 10:19:26 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: VERTICAL TUNNEL L/H

Job Number: 46912

Part Number: D38221

Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Visually inspect for proper formation of each part

PTD →

BB 09/08/02 (X3)

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

0904.06 (2)

7.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 09/04/06 (X2)

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

Check dimensions to ensure conformity to drawing tolerances.

BB 09/04/06 (X2)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

0904.06 (2)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

POSITIVE RECALL

EFFECTIVE 09.04.03 AUTH L1
RELEASED PH DATE 09.04.14

09/04/15

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/15

Job Completion



09.04.15

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D3822-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 1 Date: 09/04/15

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>46912</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>09/04/02</u>	<u>4.0</u>	<u>PART OVER HEATED</u> <u>R.C. Solio error</u>	<u>[Signature]</u>	<u>Scrap parts: destroyed. Qty 1</u> <u>Revise Solio Lead.</u>	<u>[Signature]</u> <u>09/04/06</u>	<u>[Signature]</u> <u>09/04/06</u>	<u>[Signature]</u> <u>09/04/06</u>	<u>[Signature]</u> <u>09/04/06</u>

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 46912
Description:	Part Number: D 3822-1
Inspection Dwg: D3822 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than _____"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB Date: 09/04/06

TRIMMING SECTION

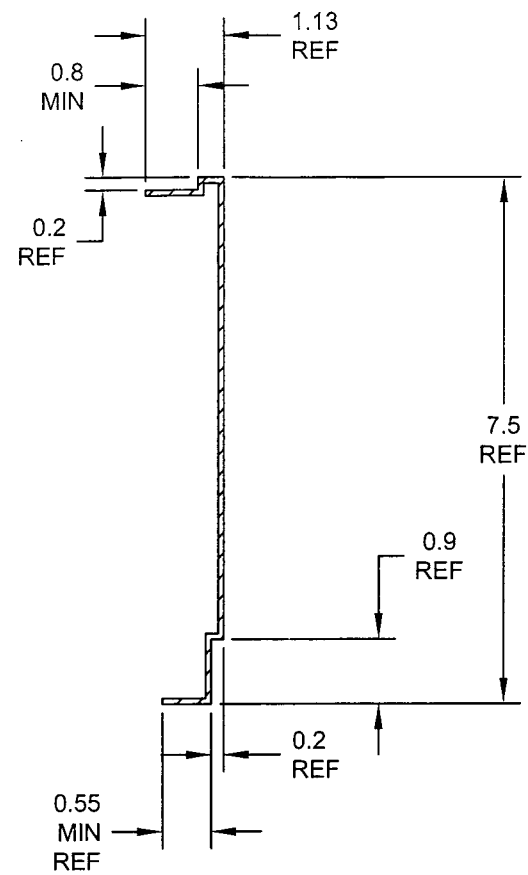
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.040	Min	.046	✓			
.040	Min	.050	✓			
.040	Min	.049	✓			
1.2	Min	1.25	✓			
.8	Min	1.125	✓			
.55	Min	.750	✓			
.3	Min	.5	✓			

Measured by: BB Date: 09/04/06

Audited by: [Signature] Date: 09-04-06

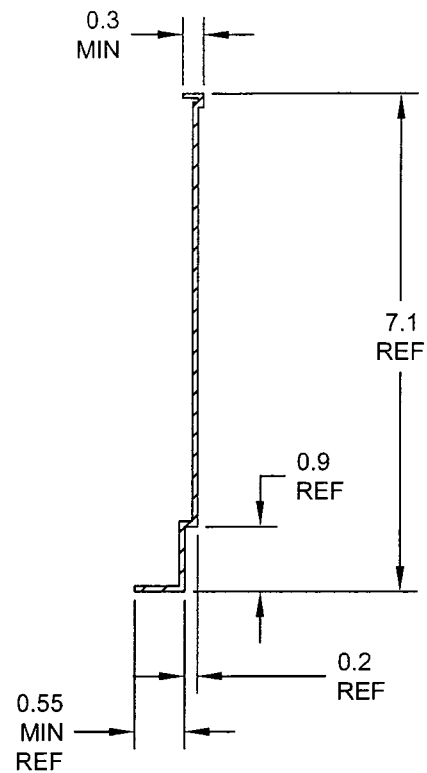
Prototype Approval: [Signature] Date: _____

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



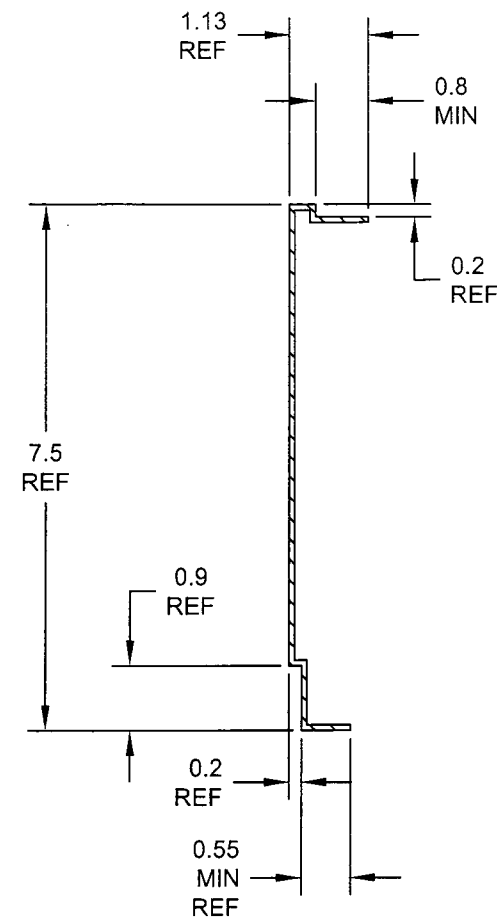
SECTION A-A

C6-1



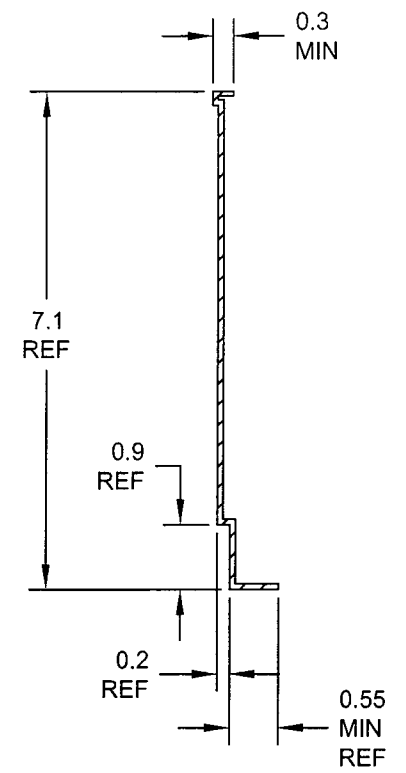
SECTION B-B

C6-1



SECTION C-C

C4-2



SECTION D-D

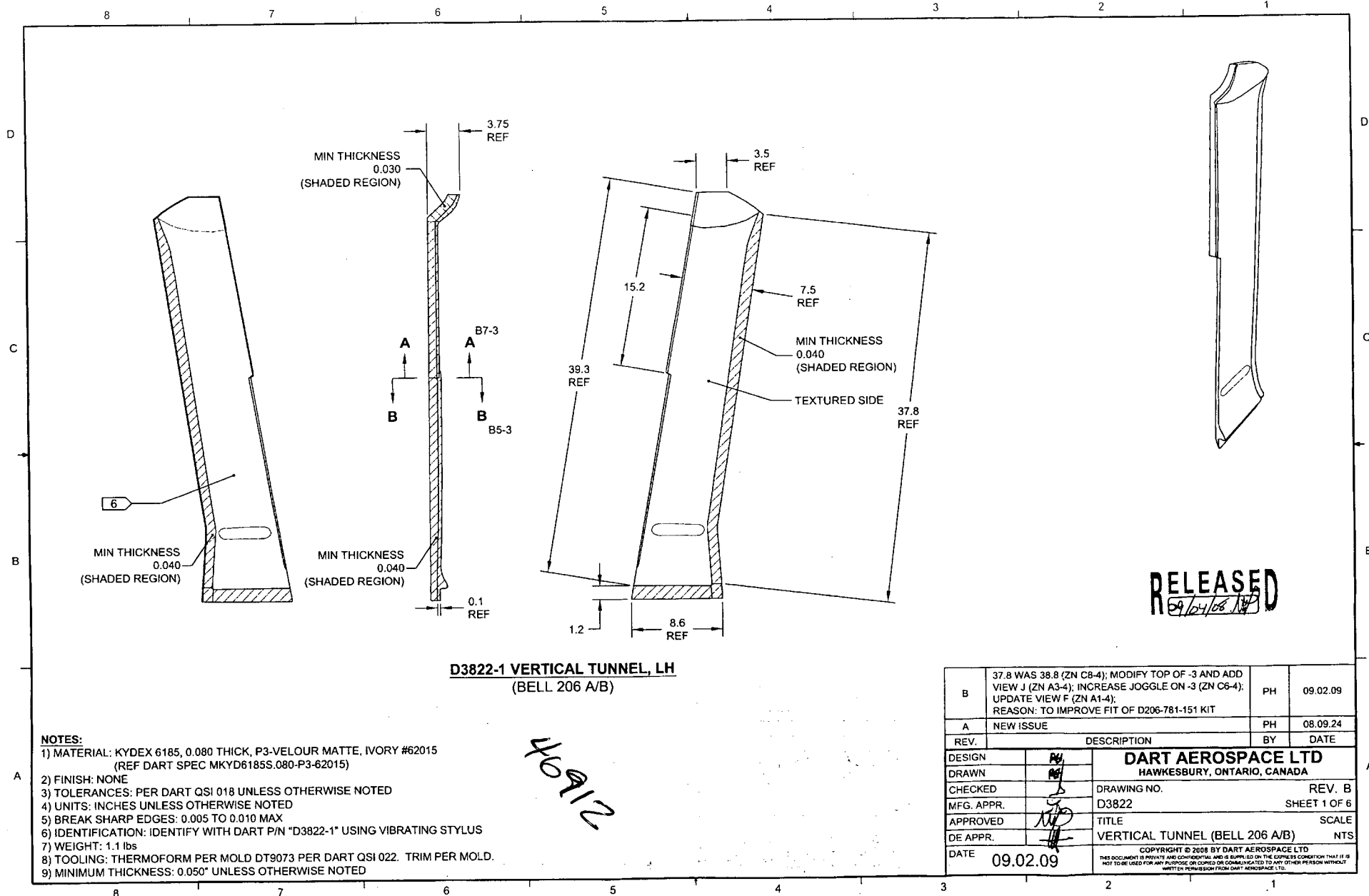
C4-2

**PRELIMINARY
ISSUE**

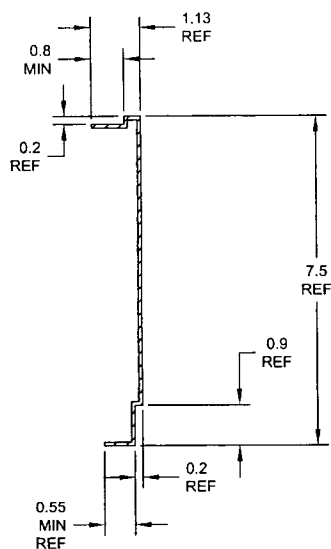
09.04.02

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RETURN TO
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40912

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	PH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3822	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		VERTICAL TUNNEL (BELL 206 A/B)	NTS
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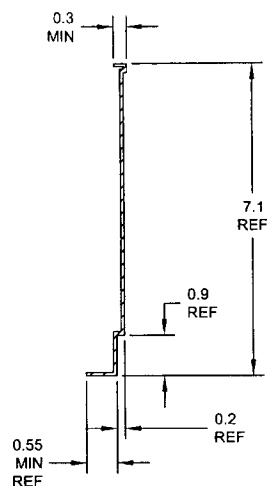


B	37.8 WAS 38.8 (ZN C8-4); MODIFY TOP OF -3 AND ADD VIEW J (ZN A3-4); INCREASE JOGGLE ON -3 (ZN C6-4); UPDATE VIEW F (ZN A1-4); REASON: TO IMPROVE FIT OF D206-781-151 KIT	PH	09.02.09
A	NEW ISSUE	PH	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.02.09		
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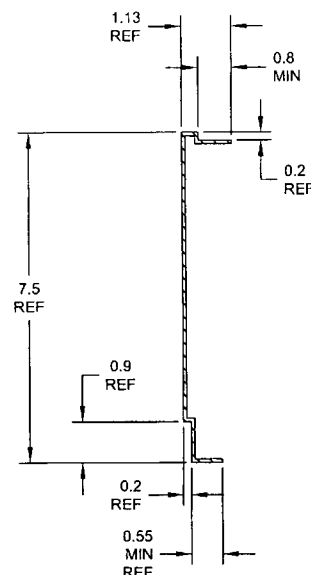
SECTION A-A

C6-1



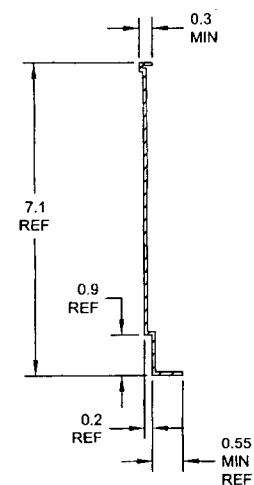
SECTION B-B

C6-1



SECTION C-C

C4-2



SECTION D-D

C4-2

46912

RELEASED

DESIGN	PA	DART AEROSPACE LTD	
DRAWN	PA	HAWKESBURY, ONTARIO, CANADA	
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